

NOV 25 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 125406

Tuesday, October 07, 2014 10:43:10 AM

125406

Page 2

Item ID: 649.8301 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cutter Sub Assembly
 Start Date: 10/06/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/06/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: MF	0.00				12			DAS 41 9-89 14-11-25
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							14/12/2 AF
150									
QC	Memo	0.00							
Quality Control									

14-11-26

DQA: _____ Date: _____



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Picklist Print

Tuesday, October 07, 2014 10:43:09 AM

Page 1

Work Order ID: 125406

125406

Parent Item: 649.8301

649 8301

Parent Item Name: Cutter Sub Assembly

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 13-10-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9711		Manufactured	No				Each	92.0000		20		DAS 41 9-89	14-11-21
646 9711									**				
Blade													

Location	Loc Qty	Loc Code
MF	92	
100268	13	
104205	8	
106350	2	
108731	5	
109392	21	
112223	2	
121406	30	
98911	11	

649.8310

Manufactured No

Each 25.0000

649 8310

Cutter Body

DAS
41
9-89 14-11-21

Location	Loc Qty	Loc Code
MF	25	
108706	16	
108707	4	
119579	5	

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Picklist Print

Tuesday, October 07, 2014 10:43:10 AM

Work Order ID: 125406

125406

Parent Item: 649.8301

649 8301

Parent Item Name: Cutter Sub Assembly

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

Each

2,818.000

DAS

41

9-89

14-11-21

MS21042L 08

Nut

Location

Loc Qty

Loc Code

ST306

2818

123900

1

125445

268

m127304

99

m127410

175

m128401

1500

m128429

69

m129541

106

m130325

600

66

MS27039-08-19

Purchased

No

Each

1,199.000

DAS

41

9-89

14-11-21

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

ST286

1000

m130325

500

m130505

500

ST506

199

124309

25

125654

78

m127904

96

66

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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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FAULT CATEGORY

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Picklist Print

Tuesday, October 07, 2014 10:43:10 AM

Page 3

Work Order ID: 125406

125406

Parent Item: 649.8301

649 8301

Parent Item Name: Cutter Sub Assembly

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149FN832P

Purchased

No

Each

7,374.000

~~120~~

DAS

NAS1149FN832P

41

9.89

14-11-21

Washer

Location

Loc Qty

Loc Code

ST275

4869

123185

30

123522

400

123900

2

125268

4437

ST294

2505

M130388

2505

132

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FAULT CATEGORY

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APICAL
INDUSTRIES, INC.

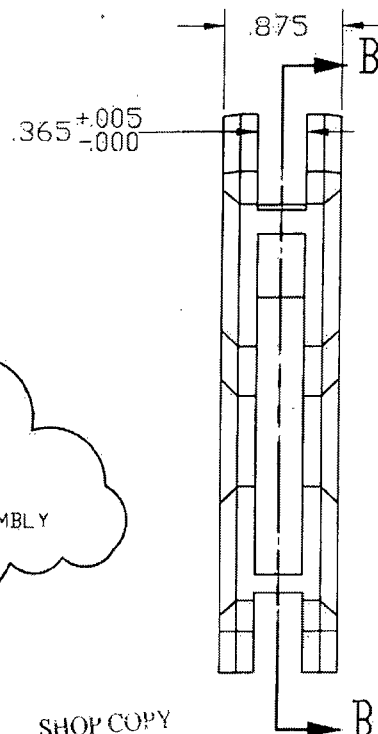
ENGINEERING CHANGE NOTICE NO. 03524				SHEET 1 OF 1	
DWG NO. 649.8300		REV: NC	PREPARED BY S. COCHRAN	DATE: 05/23/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
DWG TITLE: CUTTER SUB ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED NOTE 6, REVISED CUT OUT DIMENSION			

SHEET 1, ZONE A1 IS:

NOTES:

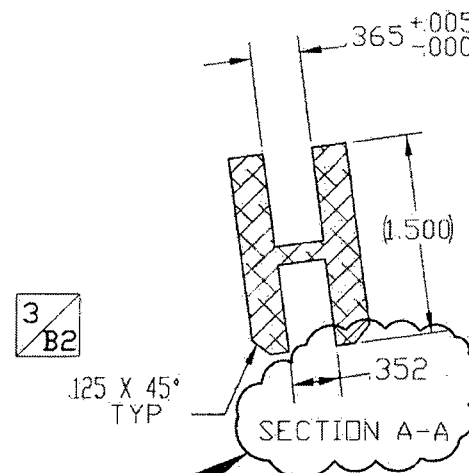
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE 1 CLASS N; 1-2 MIL MAX
- 3 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 4 IDENTIFY IAW MPP-120
- 5 APPLY F/N 6 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5 UPON ASSEMBLY

IS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125406 MJS
(4/10-09)

SHEET 2, ZONE D8 IS:



IS

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

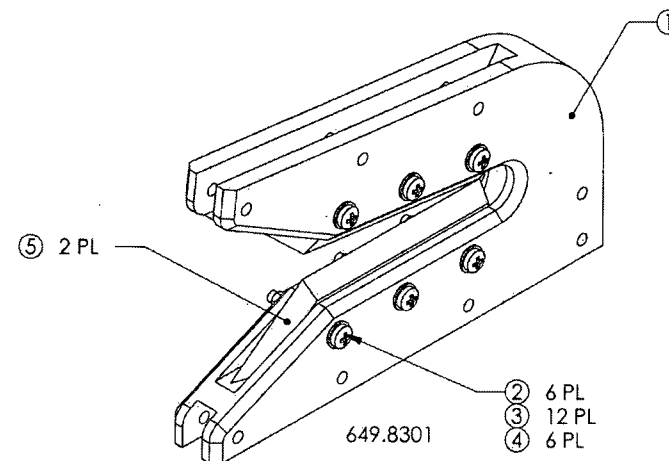
CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

FORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-18-12	P. BRAVO

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX
3. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
4. IDENTIFY IAW MPP-120
- 5 APPLY F/N 6 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5 UPON ASSEMBLY
- 6 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE



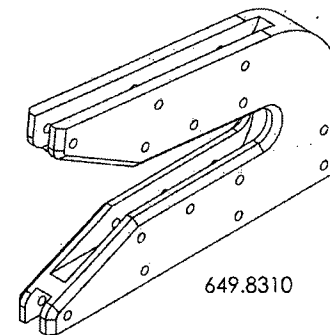
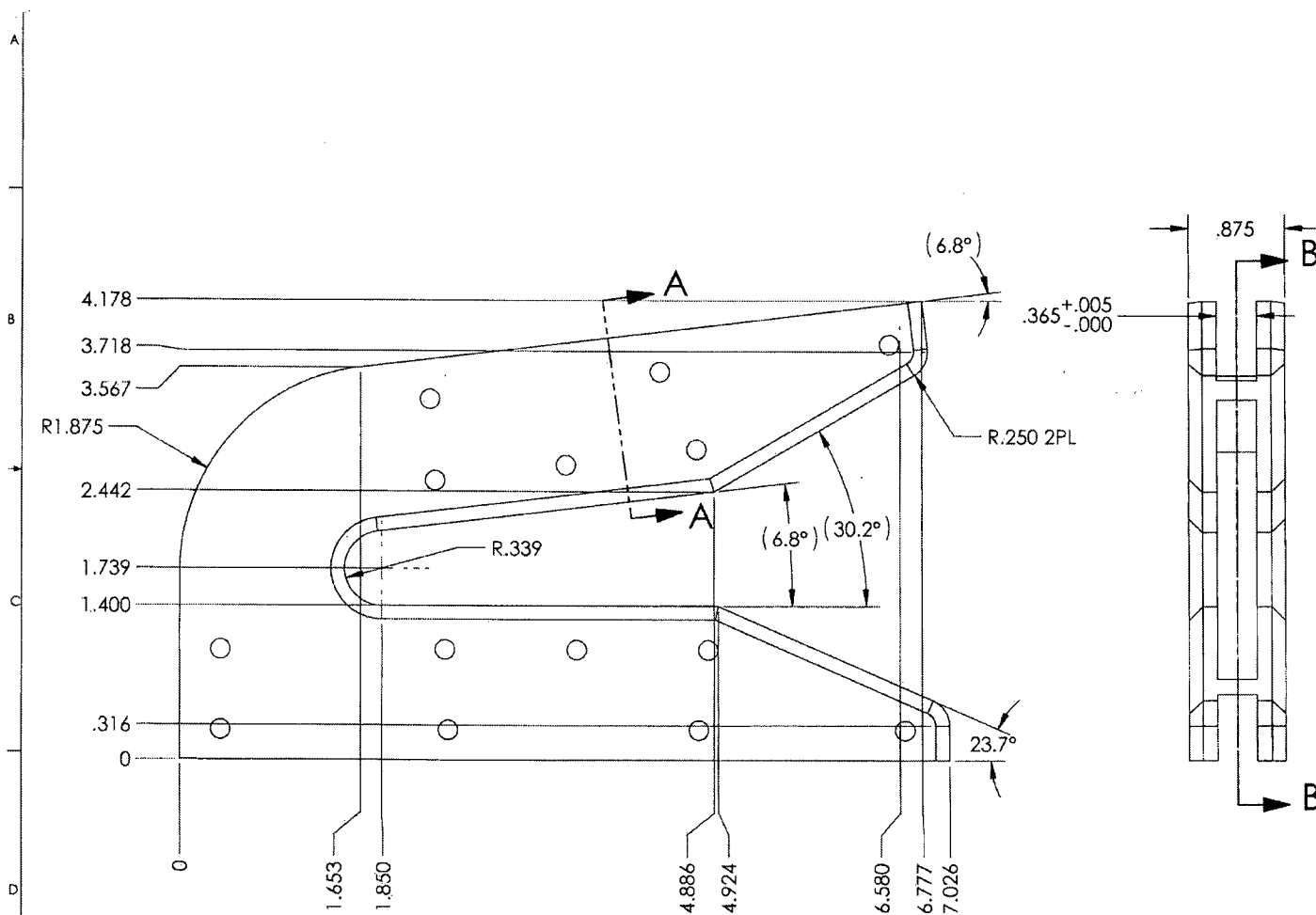
UNINCORPORATED ECN(S)

03524

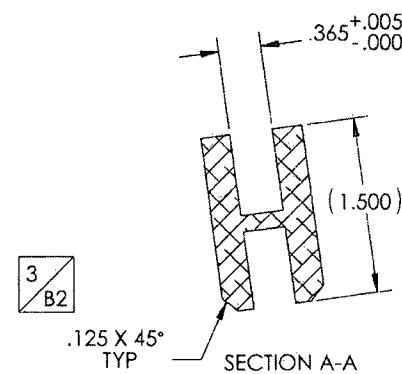
A/R	6	601.2764	RTV	LOCTITE 598	
2	5	646.9711	BLADE		
6	4	601.1541	LOCKNUT	MS21042L08	
12	3	601.2764	WASHER	NAS1149FN832P	
6	2	601.2765	SCREW	MS27039-0819	
1	1	649.8310	CUTTER BODY		
1		649.8301	CUTTER ASSY		
8301	FIND #	PART #	DESCRIPTION	MAT'L	SPEC

QTY	ORIGINAL DATE MODIFIED BY DRAWN BY S. COCHRAN P. BRAYD DRAWING APPROVAL P. BRAYD CHECKED BY CONTRACT NO.	PARTS LIST	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5335
NEXT ASSY (S) 649.4900		CUTLER SUB ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1) PLACES DECIMALS 1/16 2) PLACES DECIMALS 1/32 3) PLACES DECIMALS 1/64 4) PLACES DECIMALS 1/128 5) PLACES DECIMALS 1/256		322 CAGE CODE B 07M26 SCALE: NONE	DWG. NO. 649.8300 SHEET 1 OF 1

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649.8310



ORIGINAL DATE
04-12-12
DRAWN BY
S. COOMAN
CHECKED BY
P. DEAN
DESIGNED BY
S. COOMAN
CONTRACT NO.

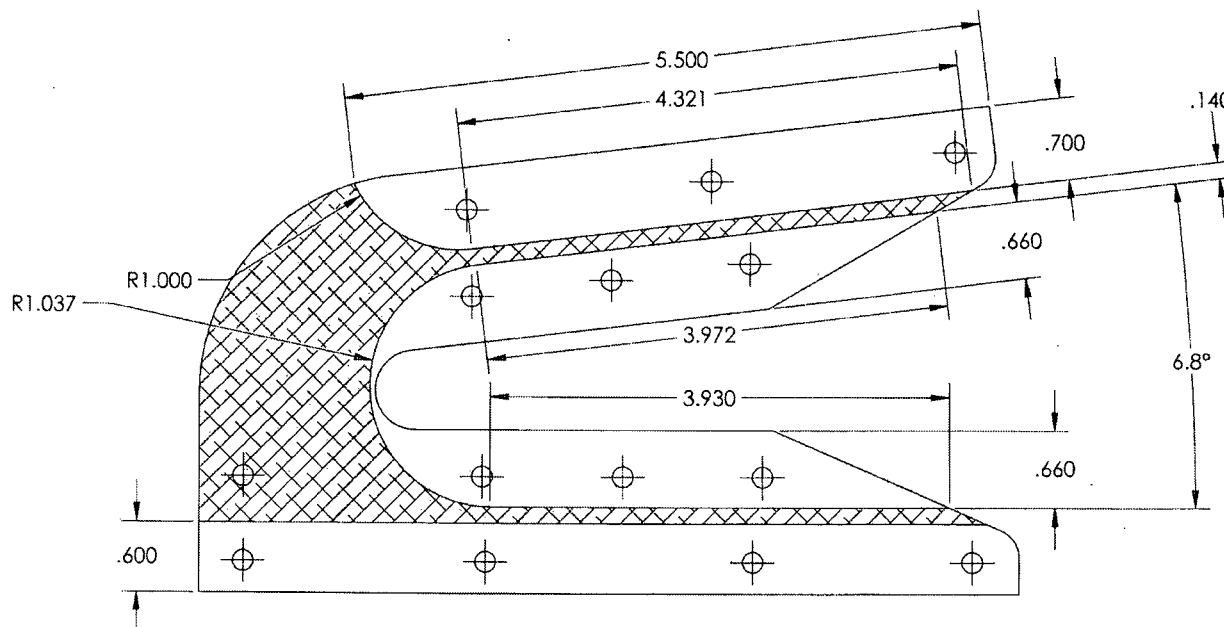
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

SIZE	CAGE CODE	DWG. NO.	REV.
B	07M26	649.8300	NC
SCALE NONE		SHEET 2 OF 4	

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SECTION B-B
SCALE 1 : 1



ORIGINAL DATE
JMC DA-YET 04-15-19
DRAWN BY
J. COONISHAN J. BRAVO
DRAWING APPROVAL
J. BRAVO
DATE 04-15-19
CONTRACT NO.

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS 1.01
3 PLACE DECIMALS 1.005
ANGLES ± .5°

SIZE / GAUGE CODE DWG. NO.
B / 07M26 649.8300

REV.
NC

SCALE NONE

SHEET 3 OF 4

1 2 3 4 5 6 7 8

0 1.000 2.541 2.683 2.825 3.281 3.531 3.780

0 .375 2.430 2.459 3.630 4.745 4.830 6.625

2.292 2.339 3.531 4.387 4.722 6.482

Ø.177 14PL

HOLE LOCATIONS +/- .002

ORIGINAL DATE (MM-DD-YY) 04-12-12	APICAL INDUSTRIES	
DRAWN BY: JCHICKER	2608 TEMPLE HEIGHTS DR.	
CHECKED BY: S. COCHRAN	OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAY	CUTTER SUB ASSY	
DATE: 06-25-12	SCALE: NONE	SHEET: 4 OF 4
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 7 PLACE DECIMALS ±.01 8 PLACE DECIMALS ±.005 ANGLES ±.5°	SHEET: B	DWG. NO. 649.8300

HOLE LOCATIONS +/- .002

ORIGINAL DATE MODALITY: 64-12-19 DRAWING BY: S. COCHIAN P. BRAVO DRAWING APPROVAL P. BRAVO 06-12-19 CHECKED DATE NO.	<h1>APICAL INDUSTRIES</h1> <p>2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 274-5300</p> <h2>CUTTER SUB ASSY</h2>			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. 3 PLACE DECIMALS 1.001 2. 3 PLACE DECIMALS 2.001 3. 3 PLACE DECIMALS 2.001 4. 3 PLACE DECIMALS 2.001	SRF B	CASE CODE 07M26	DWG. NO. 649.8300	REV. NC
	SCALE NONE		SHEET 4 OF 4	

